ModBus Operator Panel Setup Guide

To setup the modbus operator panel do the following:

1. In Mach3 go to Config->Ports and Pins
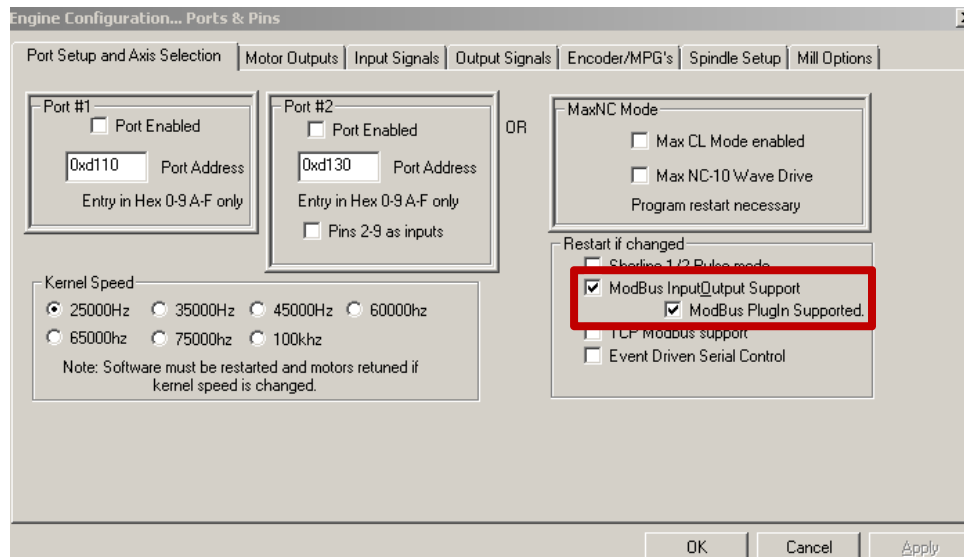2. Check *ModBus InputOutput Support* and *ModBus PlugIn Supported*

Figure 1 - Ports and Pins

3. Restart Mach3
4. Go to Config->Config Plugins and press the CONFIG button next to the MachMotion plugin
5. Press the NEW MODIO button
6. Set the *Slave Address* field to match the larger of the two small dial knobs on the back circuit board of the operator panel and the press OK
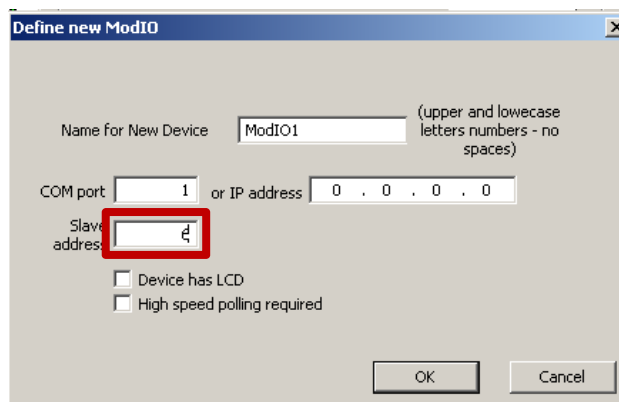

Figure 2 - New ModIO device

7. Press the SYSTEM CONFIGURATION button in the MachMotion plugin

8. Make sure that no operator panels are enabled and check the *ModBus Enabled* check box
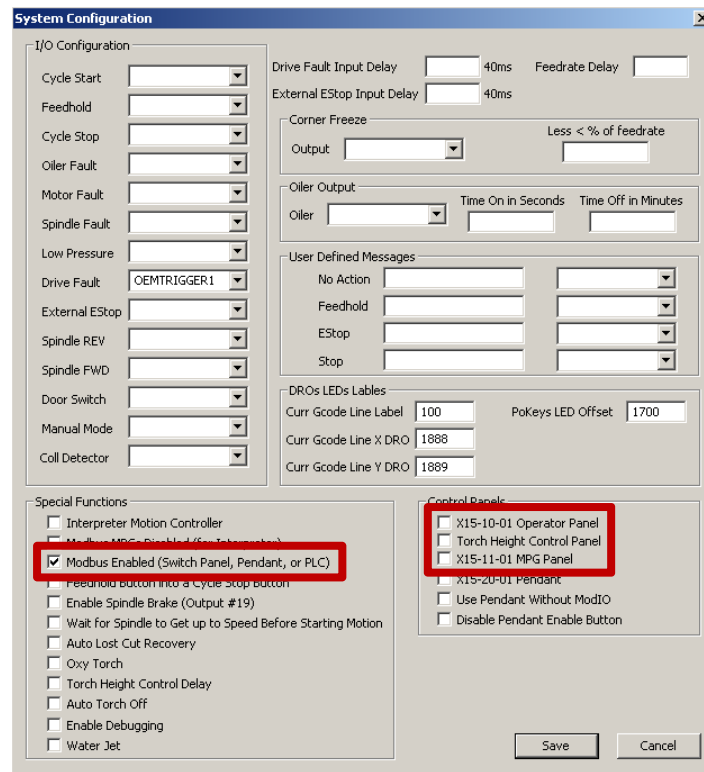

Figure 3 - MachMotion Plugin

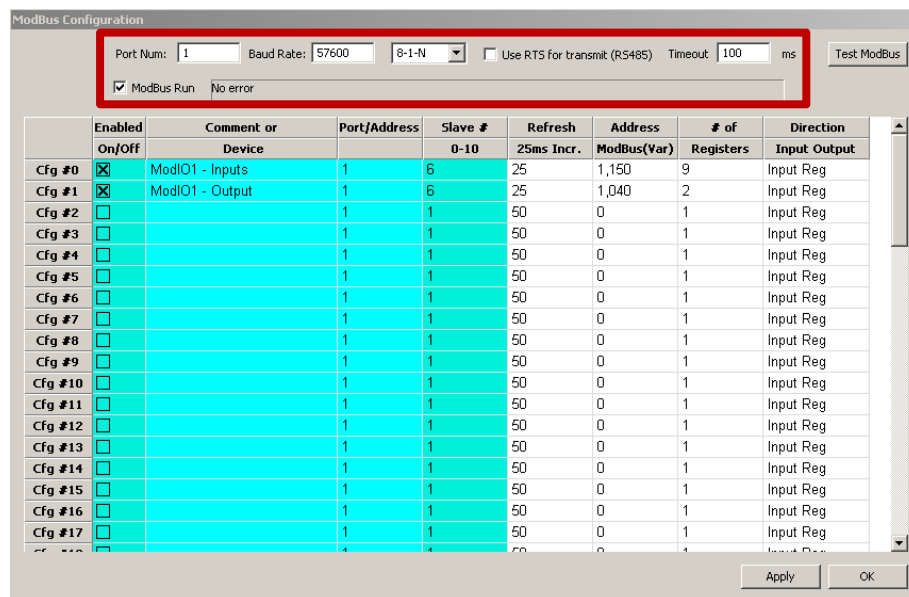9. Go to Function Config->Setup Serial ModBus Control and make sure it is configured as shown below

Figure 4 - ModBus Configuration Window

10. Restart Mach3